

## Work Order ID 72211



Page 1

Wednesday, July 20, 2011 7:53:28 AM

Item ID: D3453-1

Accept



Setup Start



Revision ID:

Item Name: Clevis

Stop



Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 107-20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan /  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3453

Rev A

B M 108.10

100



Doosan

Memo

0.00

DR 11.8.9

6

Doosan Lathe

1-Turn as per Folio FA577  
 Rev: B  
 Dwg D3453 Rev: B  
 2- Deburr as per dwg D3453

150



QC2- Inspect parts off machine FAI/FAIB

0.00

DR 11.8.7

6

QC

Memo

0.00

Quality Control

160



QC8- Inspect parts - second check

0.00

DR 11/8/9

6

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 72211**

Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

170



Identify as per dwg &amp; Stock Location: WA

Packaging

Packaging

180



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

11/8/10  
KAISER

6

QC21- Final Inspection - Work Order Release

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

0.00

GK 11/08/10

11-08-10  
6

W/O:		WORK ORDER CHANGES						
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# Picklist Print

Page 1

Wednesday, July 20, 2011 7:53:52 AM

Work Order ID: 72211



Parent Item: D3453-1



Parent Item Name: Clevis

Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: A□05.09.27□New issue□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250 		Purchased	No			100	f	44.8900	0.288	1.728 	<i>20</i>	<i>11. 8. 9</i>	

304 round bar 1.250

Location	Loc Qty	Loc Code
MAT029	44.89	
105872	12.33	
108156✓	11.33	<i>1.728</i>
111018	21.23	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD		Work Order:	72211
Description: Clevis		Part Number:	D3453-1
Inspection Dwg: D3453	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.440	/		PPR.02	
R0.25	+/-0.030	2.250	/			
0.450	+/-0.010	.450	/			
0.625	+/-0.010	.627	/			
0.063 x 45°	+/-0.010 x 0.5°	.060 x 45	/			
Ø0.129	+0.005/-0.001	.128	/		U	
3.26	+/-0.030	3.259	/			
1.00	+/-0.030	.997	/			
1.550	+/-0.010	1.551	/			
0.500	+0.010/-0.000	.503	/			
0.263 x 45°	+/-0.010 x 0.5°	.264	/			
R0.25	+/-0.010	2.25	/		U	
Ø1.13	+0.012/-0.001	1.127	/			
Ø0.500	+0.000/-0.005	.497			U	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11-8-9	Date:	11/8/9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	
C	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ	

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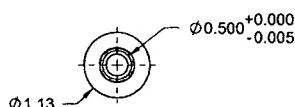
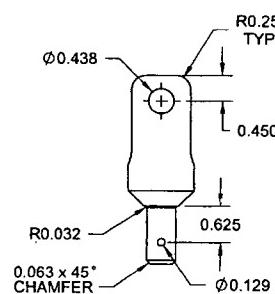
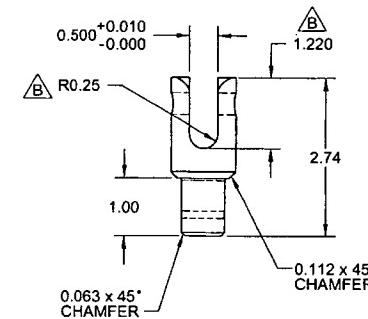
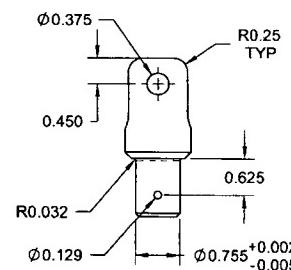
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72211 PL110720

D3453-1 CLEVISD3453-3 CLEVISRELEASED  
6/16/25 MD

## D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs  
D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1), 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018		
A	NEW ISSUE		
REV.	RF	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>UP</u>	DRAWING NO. D3453	
MFG. APPR.	<u>W</u>	REV. B SHEET 1 OF 2	
APPROVED	<u>W</u>	TITLE	SCALE
DE APPR.	<u>W</u>	CLEVIS	
DATE	09.05.21		

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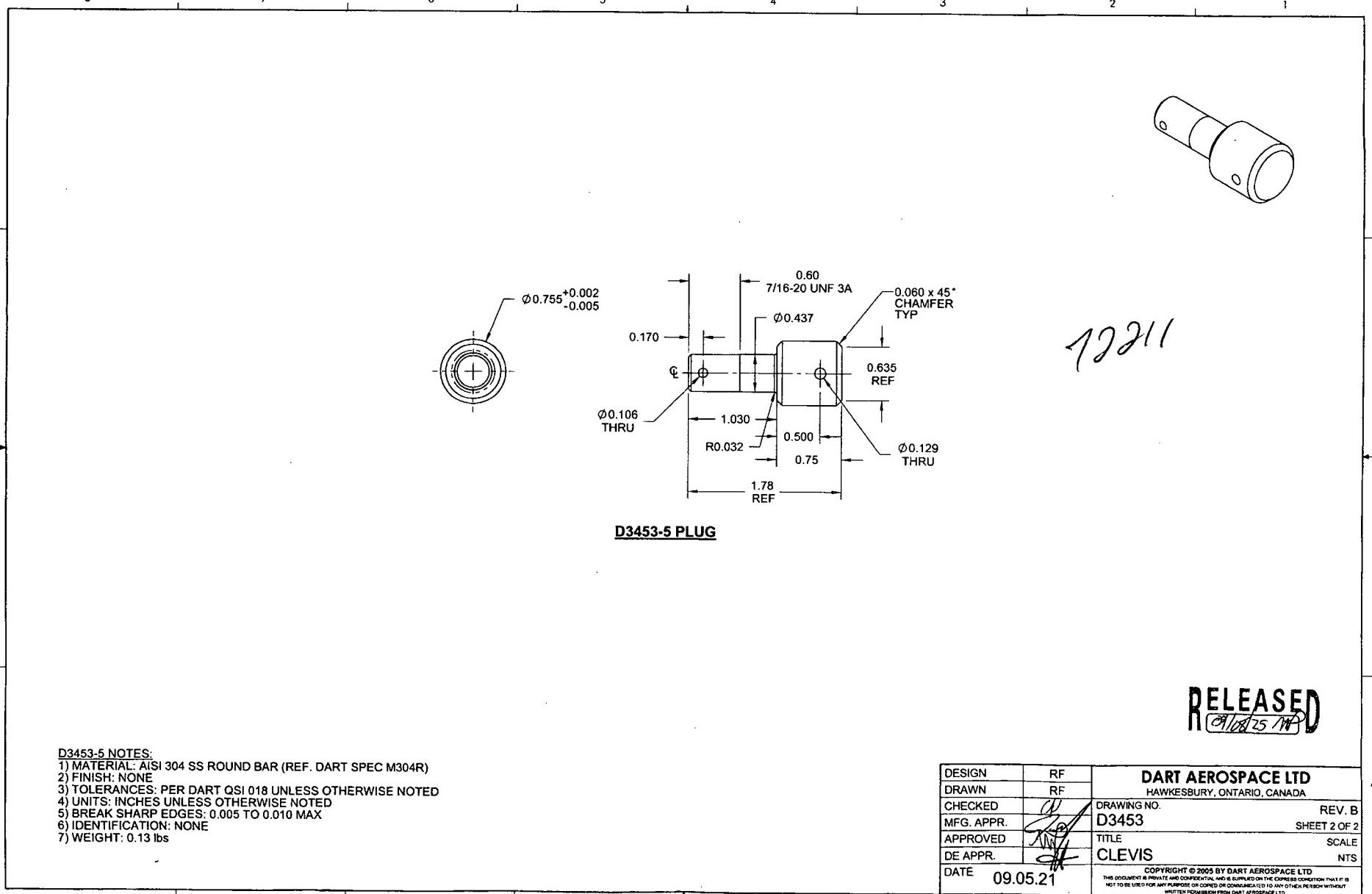
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